

WHAT IS CLAIMED IS:

1. A container system adapted to withstand an impact, the container system comprising:

a first container having a first container body; and  
a second container, comprising:

a second container body having a second body height and a second body wall thickness; and

a body recess adapted to releasibly engage the first container body of the first container, the body recess being formed on the second container body and extending along the second body height, the body recess defining at least one recess bottom corner having a recess bottom corner wall thickness which is at least identical to the second body wall thickness of the second container body, wherein the specified bottom corner wall thickness of the body recess allows the second container to withstand the impact.

2. The container system of Claim 1 wherein the second container body is fabricated from a plastic material.

3. The container system of Claim 1 wherein the second container body has a generally cylindrical configuration.

4. The container system of Claim 1 wherein the second container body has two opposing second body sides, the second container body further having proximal and distal parting

lines formed on respective ones of the opposing second body sides and extending along the second body height.

5. The container system of Claim 4 wherein the body recess is angularly offset approximately  $90^\circ$  from each of the parting lines.

6. The container system of Claim 4 wherein the second container body comprises a handle extending along the body height, the handle being substantially aligned with the proximal parting line and being disposed substantially opposite from the distal parting line, the handle further being angularly offset approximately  $90^\circ$  from the body recess.

7. The container system of Claim 1 wherein the body recess is sized and configured to accommodate only a portion of the first container body such that a remaining portion of the first container body becomes exposed outside the body recess and protrudes outward beyond the second container body.

8. The container system of Claim 7 wherein the second container body includes a plurality of lateral body extensions, each of the lateral body extensions being extended generally perpendicular to the second body height, each of the lateral body extensions further being extended partially into the body recess for capturing and retaining the portion of the first container body within the body recess.

9. The container system of Claim 7 wherein the second container body includes a supporting shelf, the supporting shelf being extended generally perpendicular to the second body height, the supporting shelf further being extended within the body recess adjacent to the at least one recess bottom corner for supporting the portion of the first container body thereupon.

10. The container system of Claim 1 wherein the at least one recess bottom corner comprises two recess bottom corners.

11. The container system of Claim 1 wherein the second body wall thickness and the recess bottom corner wall thickness range between about 0.01 inches and 0.2 inches.

12. A method of manufacturing a container system with an injection control unit having an injection unit body and an expandable molding balloon, the method comprising the steps of:

a) forming a first container of the container system;  
and

b) forming a second container of the container system, the second container having two opposing parting lines and a second body wall thickness, comprising the steps of:

1) injecting a preform material into the injection control unit;

2) strategically moving an injection control member of the injection control unit with respect to the injection unit body to regulate a flow of the preform material to the expandable molding balloon;

3) expanding the expandable molding balloon;

4) molding the preform material into the second container;

5) extending a body recess upon the second container adapted to releasibly engage the first container;

6) thickening at least one recess bottom corner of the body recess to have a recess bottom corner wall thickness which is at least identical to the second body wall thickness; and

7) withstanding an impact upon the second container due to the specified bottom corner wall thickness of the body recess.

13. The method of Claim 12 wherein the preform material in step b1) is a plastic material.

14. The method of Claim 12 wherein step b1) comprises:

i) defining an openable/closeable injection gap provided between the injection unit body and the injection control member; and

ii) injecting the preform material into the injection control unit through the injection gap when the gap is opened.

15. The method of Claim 12 wherein the injection control member in step b2) has a generally oval configuration.

16. The method of Claim 12 wherein step b2) comprises:

i) setting the injection control unit for strategically moving the injection control member so as to account for a plurality of points where the second body wall thickness undesirably changes;

ii) moving the injection control member in upward and downward directions relative to the injection unit body based upon the presetting thereof; and

iii) selectively accessing an injection gap provided between the injection control member and the injection unit body to control the flow of the preform material to the expandable molding balloon.

17. The method of Claim 12 wherein step b5) comprises:

i) offsetting the body recess approximately 90° from each of the parting lines.

18. The method of Claim 12 wherein step b5) comprises:

i) extending the handle upon the second container in substantial alignment with one of the

parting lines and substantially opposite from the remaining parting line; and

ii) offsetting the handle approximately 90° from the body recess.

19. The method of Claim 12 wherein step b5) comprises:

i) extending a supporting shelf within the body recess adjacent to the at least one recess bottom corner for supporting the first container thereupon.

20. The method of Claim 12 wherein step b6) comprises:

i) defining an outer control periphery of the injection control member;

ii) defining at least one injection scallop formed about the outer control periphery, the at least one injection scallop being designated for forming the body recess; and

iii) increasing the flow of the preform material through the at least one injection scallop to derive the at least one recess bottom corner thickened at least identical to the second body wall thickness.